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D5610-1TRN
Job Sheet 182528



Part No: D5610-1TRN

Job Qty: 1 ea

Part Name: EC130 Aft Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/27/18

Job Tracking No:

Due Date: 9/4/18

Created By: Jesse White

Type: Stock

Description:

Note: D5610 REV.A8 IPP REV:A 18.07.04 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/4/18	0.00	0.00	Start Up Crosstubes-1		MD
100	Mori Seiki	1 pcs		9/4/18	4.40	2.38	Mori Seiki TL-40		MD
110	QC	1 pcs		9/4/18	0.00	0.00	QC2-1		MD
120	Mori Seiki	1 pcs		9/4/18	0.00	2.38	Mori Seiki TL-40		MD
130	QC	1 pcs		9/4/18	0.00	0.00	QC2-1		MD
140	QC	1 pcs		9/4/18	0.00	0.00	QC8		GP 2018-09-12
145	Crosstubes	1 pcs		9/4/18	0.00	0.68	Crosstubes-1		BB
150	HandFXtube	1 pcs		9/4/18	0.00	1.00	Crosstubes-3		DR 18/09/12
160	QC	1 pcs		9/4/18	0.00	0.00	QC7-1		GP 18-11-21
170	Packaging	1 pcs		9/4/18	0.00	0.00	Packaging3-1		DR 2
180	QC21-SA	1 Ea		9/4/18	0.00	0.00	QC21		21 NOV 21 2018

Part Op 100 - 1- Fill tube with sand & install plugs 2- Face and chamfer both ends as per Folio FC197 3- Turn first taper section on
Descriptions: both side

120 - 1- Turn second taper on both side 2- Scribe part # and batch # using vibrating stylus on the cuff as per Dwg D5610-TRN

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6030-140	Tube, Seamless	1 Ea (1 ea)	90-Start up Operation	

5078768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6030-140	1	10	0

Part Specifications

Specifications could not be found.



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Container No: S108669



Part: D5610 - 1TRN

Job No: 182528

Serial No/Batch: S108669

Revision: A8

Inspector:

Exp Date:

Instructions:

Date: 09/10/18

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DART AEROSPACE LTD		Work Order: 182528
Description: Crosstube Assembly		Part Number: D5610-1TRN
Inspection Dwg:	Rev: A	Page 1 of 2

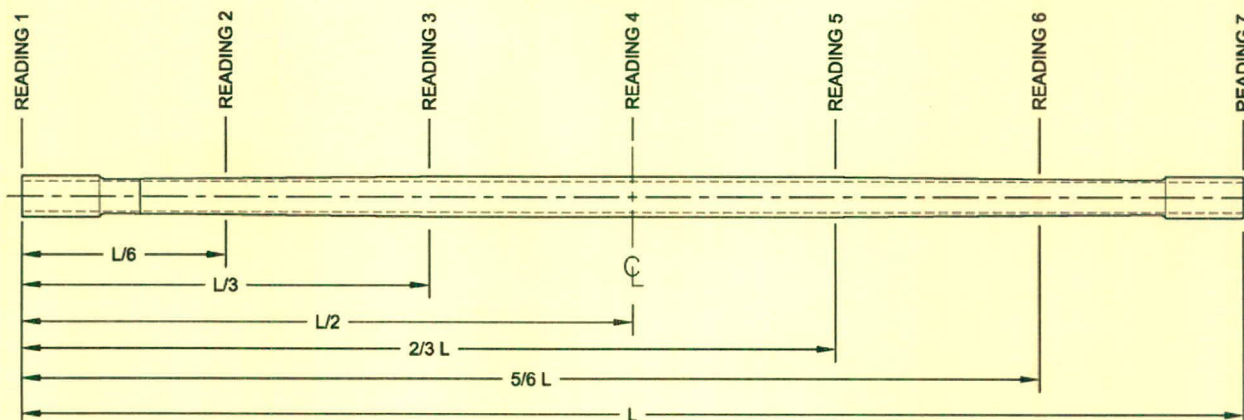
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
SIDE A	3.300	+ .005 - .000	3.305	✓		cnc-05 ↓		
	3.300	+ .005 - .000	3.305	✓				
	3.344	+ .005 - .000	3.349	✓				
	3.398	+ .005 - .000	3.403	✓				
	3.457	+ .005 - .000	3.462	✓				
	3.518	+ .005 - .000	3.523	✓				
	3.543	± .016	3.544	✓				
	3.543	± .016	3.545	✓				
SIDE B	3.300	+ .005 - .000	3.300	✓		cnc-04 ↓		
	3.300	+ .005 - .000	3.305	✓				
	3.344	+ .005 - .000	3.349	✓				
	3.398	+ .005 - .000	3.403	✓				
	3.457	+ .005 - .000	3.462	✓				
	3.518	+ .005 - .000	3.523	✓				
	3.543	± .016	3.543	✓				
	3.543	± .016	3.545	✓				
	116.26	± .060	116.25	✓		Tape		

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DART AEROSPACE LTD		Work Order: 182528
Description: Crosstube Assembly		Part Number: D5610-112N
Inspection Dwg:	Rev: A	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.195	.201	.202	.196	.007	$\pm 0.030"$ 18/09/00
READING 2 L= 19.38	.251	.256	.256	.250	.006	
READING 3 L= 38.77	.318	.326	.315	.322	.011	
READING 4 L= 58.15	.320	.324	.324	.319	.005	
READING 5 L= 77.53	.305	.315	.323	.318	.018	
READING 6 L= 96.92	.243	.253	.260	.254	.017	
READING 7 L= 116.26	.188	.197	.202	.192	.014	

Calibration Result

Actual Block Thickness: 100-400

Sitescan 250 Measured Thickness: 100-400

Measured by: MD Date: 2018-08-06	Audited by: GP Date: 2018-09-12	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	
C	12.06.01	Wall thickness form added	KJ	

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